

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018116**Date Inspected:** 02-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing (MT) – NWIT Document No's: 007200

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Bike Path. The weld designations reviewed are as follows:

1. BK004A1-004-005, 006, 001, 010, 008, 038, 004, 013, 039, 040, 041, 042
2. BK004A1-005-005, 006, 001, 010, 008, 038, 004, 013, 039, 040, 041, 042
3. BK004A1-011-030, 031, 032, 033, 039, 040, 041
4. BK004A1-002-034, 035, 036, 037, 038, 039, 040
5. BK004A1-012-032, 033, 034, 035, 036, 037, 038
6. BK005A1-001-034, 035, 036, 037, 038, 039, 040

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint BK004A1-008-005, 006 001 and 004 located on sole OBG

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of Bike Path. ZPMC Welder is identified as 062762. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of weld joint BK004A1-008-008, 010, 013 and 038 located on sole plate of OBG of Bike Path. Welder is identified as 062739. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of weld joint BK4ASD1-009-001, 002, 003, 004 located on sole plate of OBG of Bike Path. Welder is identified as 058792. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-Tc-P4-F.

FCAW welding of weld joint SB023-106-055 and 056 located on Suspender Bracket SB106E. ZPMC Welder is identified as 062739. ABF Quality Control (QC) is identified as Mr. Peng Wen Jan. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

Shielded Metal Arc Welding (SMAW) repair welding of weld joint BK004A-009-13~21 located on bottom cover plate of OBG Bike path. ZPMC welder is identified as 202338. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-1G (1F) - Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2115.

ZPMC personnel performing heat straightening on bottom cover plate of OBG bike path member identified as BK004A-007-014~021. Distortion appeared to be caused by mishandling of the welding/material. ZPMC Quality Control (QC) inspector identified as Mr. Xu Tao was present to monitor the heat straightening process. The heat straightening appeared to comply with HSR1 (B) number 9501. See the attached pictures.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	Patel,Hiranch	QA Reviewer
